

Work Order ID 127420

December-17-14 1:23:26 PM

127420

Page 1

Item ID: D412-702-343

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Shoulder Harness, 3 Point Attachment, Inertia Reel Continuous Belt, 5 Man Fwd Facing

Stop ***NS2***

Start Date: 12/15/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MCJ Date: 14-12-22 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9511	A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-702-343 CHG001								
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									
110	QC4-100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.00							
Quality Control									

(1x) DAS 46 FEB 09 2015 9-89

1 FEB 06 2015 DAS 06 9-89

(1x) DAS 46 FEB 09 2015 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127420

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127420

Page 2

Item ID: D412-702-343

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Shoulder Harness, 3 Point Attachment, Inertia Reel Continuous Belt, 5 Man Fwd Facing

Stop

NS2

Start Date: 12/15/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
120									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-702-343								
	Location: _____								
	PPP Rev: _____								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

(1)

DAS
46
9-08

FEB 09 2015

MUS 1502 09

15.2.9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 127420

127420

Parent Item: D412-702-343

D412-702-343

Parent Item Name: Shoulder Harness, 3 Point Attachment, Inertia Reel Continuous Belt, 5 Man Fwd Facing

Start Date: 12/15/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.04.30 verified:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-702-301		Manufactured	No			105	Each	0.0000	1	1		DAS 66 9-89	
D412-702-301		46							**	127873			
Harness Assembly		9-89											
D412-702-303		Manufactured	No			105	Each	2.0000	1	1		DAS 66 9-89	
D412-702-303		DAS 46							**				
Harness Assembly		9-89											
Location Loc Qty Loc Code													
ST468 2													
121531 1													
122597 1													
D412-702-305		Manufactured	No			105	Each	1.0000	1	1		DAS 66 9-89	
D412-702-305		DAS 46							**	127913			
Harness Assembly		9-89											
Location Loc Qty Loc Code													
ST468 1													
113822 1													
D412-702-307		Manufactured	No			105	Each	1.0000	1	1		DAS 66 9-89	
D412-702-307		DAS 46							**	127545			
Harness Assembly		9-89											
Location Loc Qty Loc Code													
ST468 1													
122617 1													

FEEDBACK 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 127420

127420

Parent Item: D412-702-343

D412-702-343

Parent Item Name: Shoulder Harness, 3 Point Attachment, Inertia Reel Continuous Belt, 5 Man Fwd Facing

Start Date: 12/15/14

Required Date: 12/17/14

D412-702-309

Manufactured No

105

Each

1.0000

Start Qty: 1.00

Required Qty: 1.00

D412-702-309

DAS

46

9-89

Harness Assembly

**

127420

DAS
66
9-89

Location

Loc Qty

Loc Code

ST468

1

122548

1

D412-702-059

Manufactured No

105

Each

7.0000

D412-702-059

DAS

46

9-89

Grommet

**

DAS
66
9-89

Location

Loc Qty

Loc Code

PKG12

7

107299

1

119512

6

D3761-1-041

Manufactured No

105

Each

0.0000

D3761-1-041

DAS

46

9-89

Hook & Loop Strip

**

DAS
66
9-89

D3542-1

Manufactured No

105

Each

7.0000

D3542-1

DAS

46

9-89

Bracket

**

DAS
66
9-89

Location

Loc Qty

Loc Code

ST049

7

122309

7

D3571-1

Manufactured No

105

Each

12.0000

D3571-1

DAS

46

9-89

Guide

**

DAS
66
9-89

Location

Loc Qty

Loc Code

ST050

2

121474

2

ST051A

10

122542

10

FEB 06 2015

December-17-14 1:23:25 PM

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Page 2

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WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 25%;">Skid-tube ☐</td> <td style="width: 25%;">Crosstube ☐</td> <td style="width: 25%;">Water Jet ☐</td> <td style="width: 25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

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Work Order ID: 127420

127420

Parent Item: D412-702-343

D412-702-343

Parent Item Name: Shoulder Harness, 3 Point Attachment, Inertia Reel Continuous Belt, 5 Man Fwd Facing

Start Date: 12/15/14

Required Date: 12/17/14

D3571-3	Manufactured	No	105	Each	11.0000	Start Qty: 1.00	Required Qty: 1.00	
D3571-3						**	2	DAS
Guide							132648	06
								9-89

	Location	Loc Qty	Loc Code
D3578-041	ST050	11	
D3578-041	105070	11	2
Doubler		105	Each 106.0000
			**
			6
			DAS
			06
			9-89

	Location	Loc Qty	Loc Code
D3610-041	ST050	106	
D3610-041	122221	17	6
Bracket	124472	29	
	126312	60	
		105	Each 12.0000
			**
			2
			DAS
			06
			9-89

	Location	Loc Qty	Loc Code
D3618-1	ST051	2	
D3618-1	104326	2	
Cap	ST051A	10	
	121597	10	
		105	Each 76.0000
			**
			2
			DAS
			06
			9-89

	Location	Loc Qty	Loc Code
	ST051	76	
	104537	76	2

FEB 06 2015

DQA: _____ Date: _____



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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 4

Work Order ID: 127420

127420

Parent Item: D412-702-343

D412-702-343

Parent Item Name: Shoulder Harness, 3 Point Attachment, Inertia Reel Continuous Belt, 5 Man Fwd Facing

Start Date: 12/15/14

Required Date: 12/17/14

AN4-10A	DAS	Purchased	No	105	Each	34.0000	Start Qty: 1.00	Required Qty: 1.00
AN4-10A	46						4	
Bolt	9-89						**	3715373
								DAS
								66
								9-89

Location	Loc Qty	Loc Code
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CA	18	
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M129682	18	
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ST345	16	
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M130466	16	
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AN4-44A	DAS	Purchased	No	105	Each	23.0000		
AN4-44A	46						**	
Bolt	9-89							DAS
								66
								9-89

Location	Loc Qty	Loc Code
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ST341	23	
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122800	23	
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MS24693-S274	DAS	Purchased	No	105	Each	82.0000		
MS24693-S274	46						**	
Screw	9-89							DAS
								66
								9-89

Location	Loc Qty	Loc Code
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ST292	82	
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124670	82	
--------	----	--

MS24694-S56	DAS	Purchased	No	105	Each	64.0000		
MS24694-S56	46						**	
SCREW	9-89							DAS
								66
								9-89

Location	Loc Qty	Loc Code
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ST289	64	
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m128402	64	
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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--

Picklist Print

December-17-14 1:23:25 PM

Page 5

Work Order ID: 127420

127420

Parent Item: D412-702-343

D412-702-343

Parent Item Name: Shoulder Harness, 3 Point Attachment, Inertia Reel Continuous Belt, 5 Man Fwd Facing

Start Date: 12/15/14

Required Date: 12/17/14

MS24694-S58

Purchased

No

105

Each

43.0000

Start Qty: 1.00

Required Qty: 1.00

MS24694-S58

SCREW

DAS

46

9-89

Location

Loc Qty

Loc Code

ST289

43

123352

43

105

Each

28.0000

1

1

**

DAS

06

9-89

MS24694-S60

Purchased

No

105

Each

28.0000

1

1

**

DAS

06

9-89

MS24694-S60

Screw

DAS

46

9-89

Location

Loc Qty

Loc Code

ST289

28

104407

28

105

Each

6,559.000

6

6

**

DAS

06

9-89

NAS1149D0463J

Purchased

No

105

Each

6,559.000

6

6

**

NAS1149D0463J

WASHER

DAS

46

9-89

Location

Loc Qty

Loc Code

CA

397

M129682

397

GA

408

M129390

408

ST260a

1155

M129390

1155

ST269

4599

M129390

12

M130799

4587

FEB 06 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--

Picklist Print

December-17-14 1:23:26 PM

Page 6

Work Order ID: 127420

127420

Parent Item: D412-702-343

D412-702-343

Parent Item Name: Shoulder Harness, 3 Point Attachment, Inertia Reel Continuous Belt, 5 Man Fwd Facing

Start Date: 12/15/14

Required Date: 12/17/14

NAS1149D0416J

Purchased

No

105

Each

241.0000

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0416J

WASHER

DAS
46
9-89

**

12/17/14

DAS

06
9-89

Location

Loc Qty

Loc Code

GA

9

m126254

9

ST270

232

m125773

232

MS21042L4

Purchased

No

105

Each

3,672.000

6

6

MS21042L4

Locknut

DAS

46

9-89

**

Location

Loc Qty

Loc Code

FP001

42

m124231

42

GA

704

m127813

704

ST260a

2000

m130799

2000

ST305

926

426

426

m130922

500

CR3212-4-4

Purchased

No

105

Each

27.0000

12

12

CR3212-4-4

CHERRY RIVET

DAS

46

9-89

**

FEB 06 2015

Location

Loc Qty

Loc Code

ST320

27

m126534

27

DAS

06

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-702 REV. E AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-702 REV. 3
REF TCCA STC SH04-7
REF FAA STC SR01997NY
REF EASA STC EASA.I.M.R.S.00710

This service instruction adds several kits equipped with improved inertia reels:

The Dart **D412-702-341** 13-Man Shoulder Harness Kit provides 3-point harnesses with inertia reels and joined lap and shoulder belts for all 13 passenger seating positions in the aircraft cabin. The kit also contains hardpoints for securing the harnesses. The harnesses for this kit meet the requirements of TSO-C114 and replace the existing lap belts. This kit should be installed similar to the D412-702-041B kit, as detailed in Table 1 of this service instruction.

The Dart **D412-702-343** 5-Man Forward Facing Shoulder Harness Kit provides 3-point harnesses with inertia reels and joined lap and shoulder belts for the 5 forward facing seating positions in the aircraft cabin. The kit also contains hardpoints for securing the harnesses. The harnesses for this kit meet the requirements of TSO-C114 and replace the existing lap belts. This kit should be installed similar to the D412-702-043B kit, as detailed in Table 1 of this service instruction.

The Dart **D412-702-345** 4-Man Shoulder Harness Kit provides 3-point harnesses with inertia reels and joined lap and shoulder belts for the 4 aft facing seating positions in the aircraft cabin. The kit also contains hardpoints for securing the harnesses. The harnesses for this kit meet the requirements of TSO-C114 and replace the existing lap belts. This kit should be installed similar to the D412-702-045B kit, as detailed in Table 1 of this service instruction.

The Dart **D412-702-347** 4-Man Shoulder Harness Kit provides 3-point harnesses with inertia reels and joined lap and shoulder belts for the 4 side facing seating positions in the aircraft cabin. The kit also contains hardpoints for securing the harnesses. The harnesses for this kit meet the requirements of TSO-C114 and replace the existing lap belts. This kit should be installed similar to the D412-702-047B kit, as detailed in Table 1 of this service instruction.

The Dart **D412-702-349** 1-Man Shoulder Harness Kit provides a 3-point harness with an inertia reel and joined lap and shoulder belts for the center forward facing seating position in the aircraft cabin. The kit also contains hardpoints for securing the harness. The harness for this kit meets the requirements of TSO-C114 and replaces the existing lap belts. This kit should be installed similar to the D412-702-049B kit, as detailed in Table 1 of this service instruction.

The Dart **D412-702-351** 1-man 3-point shoulder harness kits are available for the outboard seats of the 5-man forward facing bench in Bell 205/212/214/412 model aircraft. The kit can be installed LH or RH. These kits should be installed similar to the D412-702-051B/052B kits, as detailed in Table 1 of this service instruction.

The Dart **D214-702-337** 5-Man Aft Facing Shoulder Harness Kit provides 3-point harnesses with inertial reels and joined lap and shoulder belts for the 5-man aft facing seat installed in the Bell 214B/B1 model aircraft. This kit should be installed similar to the D214-702-037B kit, as detailed in Table 1 of this service instruction.

The Dart **D205-702-353** 4-Man Aft Facing Shoulder Harness Kit provides 3-point harnesses with inertial reels and joined lap and shoulder harnesses for the 4-man aft facing seat installed in the UH-1 model aircraft. This kit should be installed similar to the D205-702-053B kit, as detailed in Table 1 of this service instruction.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.03.22
CERT. NO.: SH04-7
ISSUE NO.: 3

A	NEW ISSUE	CP	10.03.18
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>qp</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9511	SHEET 1 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	NEW SHOULDER HARNESS KITS	NTS
DATE	10.03.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RETURN TO
DRAWING
NO. 10-11-20
MUS
WORK ORDER
W/OUT NOTICE
SUBJECT TO AMENDMENT

INSTALLATION

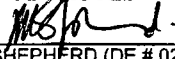
The Dart D412-702-3XX kits should be installed similar to the kits in Installation Instructions IIN-D412-702 Rev. E or Dart Service Instruction (DSI) listed below:

TABLE 1

Part Number	Description	Install similar to:
D412-702-341	Shoulder Harness Kit	D412-702-041B (IIN-D412-702, DSI 9408)
D412-702-343	Shoulder Harness Kit	D412-702-043B (IIN-D412-702, DSI 9453 [214], DSI 9408)
D412-702-345	Shoulder Harness Kit	D412-702-045B (IIN-D412-702, DSI 9469)
D412-702-347	Shoulder Harness Kit	D412-702-047B (IIN-D412-702, DSI 9408)
D412-702-349	Shoulder Harness Kit	D412-702-049B (IIN-D412-702, DSI 9408)
D412-702-351	Shoulder Harness Kit	D412-702-051B (LH) (DSI 9397, DSI 9408) D412-702-052B (RH) (DSI 9397, DSI 9408)
D214-702-337	Shoulder Harness Kit	D214-702-037B (DSI 9454)
D205-702-353	Shoulder Harness Kit	D205-702-053B (DSI 9460)
D412-702-301	Harness Assembly	D412-702-101B (IIN-D412-702)
D412-702-303	Harness Assembly	D412-702-103B (IIN-D412-702)
D412-702-305	Harness Assembly	D412-702-105B (IIN-D412-702)
D412-702-307	Harness Assembly	D412-702-107B (IIN-D412-702)
D412-702-309	Harness Assembly	D412-702-109B (IIN-D412-702)
D412-702-311	Harness Assembly	D412-702-111B (IIN-D412-702)
D412-702-313	Harness Assembly	D412-702-113B (IIN-D412-702)
D412-702-315	Harness Assembly	D412-702-115B (IIN-D412-702)
D412-702-317	Harness Assembly	D412-702-117B (IIN-D412-702)
D412-702-319	Harness Assembly	D412-702-119B (DSI 9454)
D412-702-321	Harness Assembly	D412-702-121B (DSI 9454, DSI 9469)
D412-702-323	Harness Assembly	D412-702-123B (DSI 9454, DSI 9469)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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BY: 
D. SHEPHERD (DE # 02)

DATE: 10.03.22
CERT. NO.: SH04-7
ISSUE NO.: 3

DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	99	
CHECKED	J	DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9511 SHEET 2 OF 6
APPROVED	140	TITLE SCALE
DE APPR.	H	NEW SHOULDER HARNESS KITS NTS
DATE	10.03.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

PARTS LIST

TABLE 2

QTY -341	QTY -343	QTY -345	QTY -347	QTY -349	QTY -351	Part Number	Description
X						D412-702-341	Dart 13-Man 3-Point Shoulder Harness Kit
	X					D412-702-343	Dart 5-Man 3-Point Forward Facing Shoulder Harness Kit
		X				D412-702-345	Dart 4-Man 3-Point Aft Facing Shoulder Harness Kit
			X			D412-702-347	Dart 4-Man 3-Point Side Facing Shoulder Harness Kit
				X		D412-702-349	Dart 1-Man 3-Point Forward Shoulder Harness Kit
					X	D412-702-351	Dart 1-Man 3-Point Shoulder Harness Kit
1	1		1	1		D412-702-059	GROMMET KIT
9	5		4	1	1	D3761-1-041	HOOK AND LOOP STRIP (DSI 9408)
2	1		1			D412-702-301	HARNESS ASSEMBLY (NEW)
1*	1*		1*			D3573-7	ADAPTER
1*	1*		1*			D4088-041	SHOULDER HARNESS (NEW)
4*	4*		4*			MS24693S272	SCREW
4*	4*		4*			AN960JD10LL	WASHER
4*	4*		4*			MS21042L3	NUT
2	1		1			D412-702-303	HARNESS ASSEMBLY (NEW)
1*	1*		1*			D3573-8	ADAPTER
1*	1*		1*			D4088-041	SHOULDER HARNESS (NEW)
4*	4*		4*			MS24693S272	SCREW
4*	4*		4*			AN960JD10LL	WASHER
4*	4*		4*			MS21042L3	NUT
1	1			1		D412-702-305	HARNESS ASSEMBLY (NEW)
1*	1*			1*		D3573-1	ADAPTER
1*	1*			1*		D4088-041	SHOULDER HARNESS (NEW)
4*	4*			4*		MS24693S273	SCREW
4*	4*			4*		AN960JD10LL	WASHER
4*	4*			4*		MS21042L3	NUT
1	1				1	D412-702-307	HARNESS ASSEMBLY (NEW)
1*	1*				1*	D3573-3	ADAPTER
1*	1*				1*	D4088-041	SHOULDER HARNESS (NEW)
4*	4*				4*	MS24693S272	SCREW
4*	4*				4*	AN960JD10LL	WASHER
4*	4*				4*	MS21042L3	NUT
1	1					D412-702-309	HARNESS ASSEMBLY (NEW)
1*	1*					D3573-3	ADAPTER
1*	1*					D4088-041	SHOULDER HARNESS (NEW)
4*	4*					MS24693S272	SCREW
4*	4*					AN960JD10LL	WASHER
4*	4*					MS21042L3	NUT

* denotes that part is included in assembly above

continued next page...

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.03.22
CERT. NO.: SH04-7
ISSUE NO.: 3

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9511	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		NEW SHOULDER HARNESS KITS	NTS
DATE	10.03.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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...continued from previous page

QTY -341	QTY -343	QTY -345	QTY -347	QTY -349	QTY -351	Part Number	Description
1		1				D412-702-311	HARNESS ASSEMBLY (NEW)
1*		1*				D3570-1	BRACKET
1*		1*				D4088-043	SHOULDER HARNESS (NEW)
4*		4*				MS24694S50	SCREW
4*		4*				AN960JD10L	WASHER
4*		4*				MS21042L3	NUT
1		1				D412-702-313	HARNESS ASSEMBLY (NEW)
1*		1*				D3570-2	BRACKET
1*		1*				D4088-043	SHOULDER HARNESS (NEW)
4*		4*				MS24694S50	SCREW
4*		4*				AN960JD10L	WASHER
4*		4*				MS21042L3	NUT
1			1			D412-702-315	HARNESS ASSEMBLY (NEW)
1*			1*			D3573-5	ADAPTER
1*			1*			D4088-041	SHOULDER HARNESS (NEW)
4*			4*			MS24693S272	SCREW
4*			4*			AN960JD10LL	WASHER
4*			4*			MS21042L3	NUT
1			1			D412-702-317	HARNESS ASSEMBLY (NEW)
1*			1*			D3573-5	ADAPTER
1*			1*			D4088-041	SHOULDER HARNESS (NEW)
4*			4*			MS24693S272	SCREW
4*			4*			AN960JD10LL	WASHER
4*			4*			MS21042L3	NUT
1		1				D412-702-321	HARNESS ASSEMBLY (NEW)
1*		1*				D3570-3	BRACKET
1*		1*				D4088-043	SHOULDER HARNESS (NEW)
4*		4*				MS24694S50	BOLT
4*		4*				AN960JD10L	WASHER
4*		4*				MS21042L3	NUT
1		1				D412-702-323	HARNESS ASSEMBLY (NEW)
1*		1*				D3570-4	BRACKET
1*		1*				D4088-043	SHOULDER HARNESS (NEW)
4*		4*				MS24694S50	BOLT
4*		4*				AN960JD10L	WASHER
4*		4*				MS21042L3	NUT

* denotes that part is included in assembly above

continued next page...

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.03.22
CERT. NO.: SH04-7
ISSUE NO.: 3

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9511	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		NEW SHOULDER HARNESS KITS	NTS
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...continued from previous page

QTY -341	QTY -343	QTY -345	QTY -347	QTY -349	QTY -351	Part Number	Description
2	2					D3542-1	BRACKET
7	3		4	1		D3571-1	GUIDE
2	2					D3571-3	GUIDE
2		2				D3572-041	GUIDE ASSEMBLY
12	6		6	2		D3578-041	DOUBLER
2	2					D3610-041	BRACKET
2	2					D3618-1	CAP
4	4					AN4-10A	BOLT
2		2				AN4-16A	BOLT
4		4				AN4-25A	BOLT
4		4				AN4-27A	BOLT (DSI 9469)
2	2					AN4-44A	BOLT
2	2					MS24693S274	SCREW
3	3			1		MS24694S56	SCREW
10	2		8			MS24694S58	SCREW
1	1			1		MS24694S60	SCREW
26	6	20				AN960JD416	WASHER
4	4					AN960JD416L	WASHER
12	6	6				MS21042L4	NUT
24	12		12	4		CR3212-4-4	RIVET

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: MSH d-
D. SHEPHERD (DE # 02)

DATE: 10.03.22
CERT. NO.: SH04-7
ISSUE NO.: 3

DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	92	
CHECKED	J	DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9511 SHEET 5 OF 6
APPROVED	MSH	TITLE SCALE
DE APPR.	TH	NEW SHOULDER HARNESS KITS NTS
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TABLE 3

QTY -337	QTY -353	Part Number	Description
X		D214-702-337	Dart 5-Man 3 Point Aft Facing Shoulder Harness Kit, for 214 Aircraft
	X	D205-702-353	Dart 4-Man 3 Point Aft Facing Shoulder Harness Kit, for UH-1 Aircraft
1	2	D412-702-311	HARNESS ASSEMBLY (NEW) -> SEE TABLE 2
1	2	D412-702-313	HARNESS ASSEMBLY (NEW) -> SEE TABLE 2
1		D412-702-321	HARNESS ASSEMBLY (NEW) -> SEE TABLE 2
1		D412-702-323	HARNESS ASSEMBLY (NEW) -> SEE TABLE 2
1		D412-702-319	HARNESS ASSEMBLY (NEW)
1*		D3925-041	BRACKET
1*		D4088-043	SHOULDER HARNESS ASSEMBLY (NEW)
4*		MS24694S50	BOLT
4*		AN960JD10L	WASHER
4*		MS21042L3	NUT
	1	D3572-043	GUIDE ASSY
	1	D3572-044	GUIDE ASSY
1		D3920-041	SEATBELT GUIDE ASSEMBLY
2		D3920-5	SEATBELT GUIDE
1	6	AN4-16A	BOLT
1		AN4-21A	BOLT
7		AN4-25A	BOLT
18	12	AN960JD416	WASHER
9	6	MS21042L4	NUT

* denotes that part is included in assembly above

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